

Date: Tuesday, 3/20/2007 12:03:36 PM
User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT CAP
Job Number :	31335		
Estimate Number :	10312		
P.O. Number :	NIA	Part Number :	D2646
This Issue :	3/20/2007	S.O. No. :	NIA
Prsht Rev. :	NC	Drawing Number :	D2646 REV C
First Issue :	NIA	Project Number :	N/A
Previous Run :	30119	Drawing Revision :	C
		Material :	NIA
Written By :		Due Date :	4/5/2007
Checked & Approved By :	Qty: 50 Um: Each		
Comment :	Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM Est Rev:H Changed Inserts 07-02-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 3383

1-Spin as per Dwg D2646

2-Material release note required

C207103122

(50)

Each

2.0	D2646P	Aft Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

AFT CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

07/04/10 100

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2646

07/04/12 100 counted

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646.

2-Open holes to .250" and sink as per Dwg D2646.

3-Deburr

B

X100
ml 07/04/23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 07/05/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 12:03:37 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 31335

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



100X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-R

07/04/24

7.0

POWDER COATING

POWDER COATING



M1103706

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-R

070424

100

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F-R

07/04/30

100

9.0

ALS71032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

INSERT

Batch: M102475

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

F-R

07/04/30

100

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

070501

QSP 019

12.0

PACKAGING 1

PACKAGING RESOURCE #1



100X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FR9

M-R

07/05/01

100

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/01

Job Completion



u 070501

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

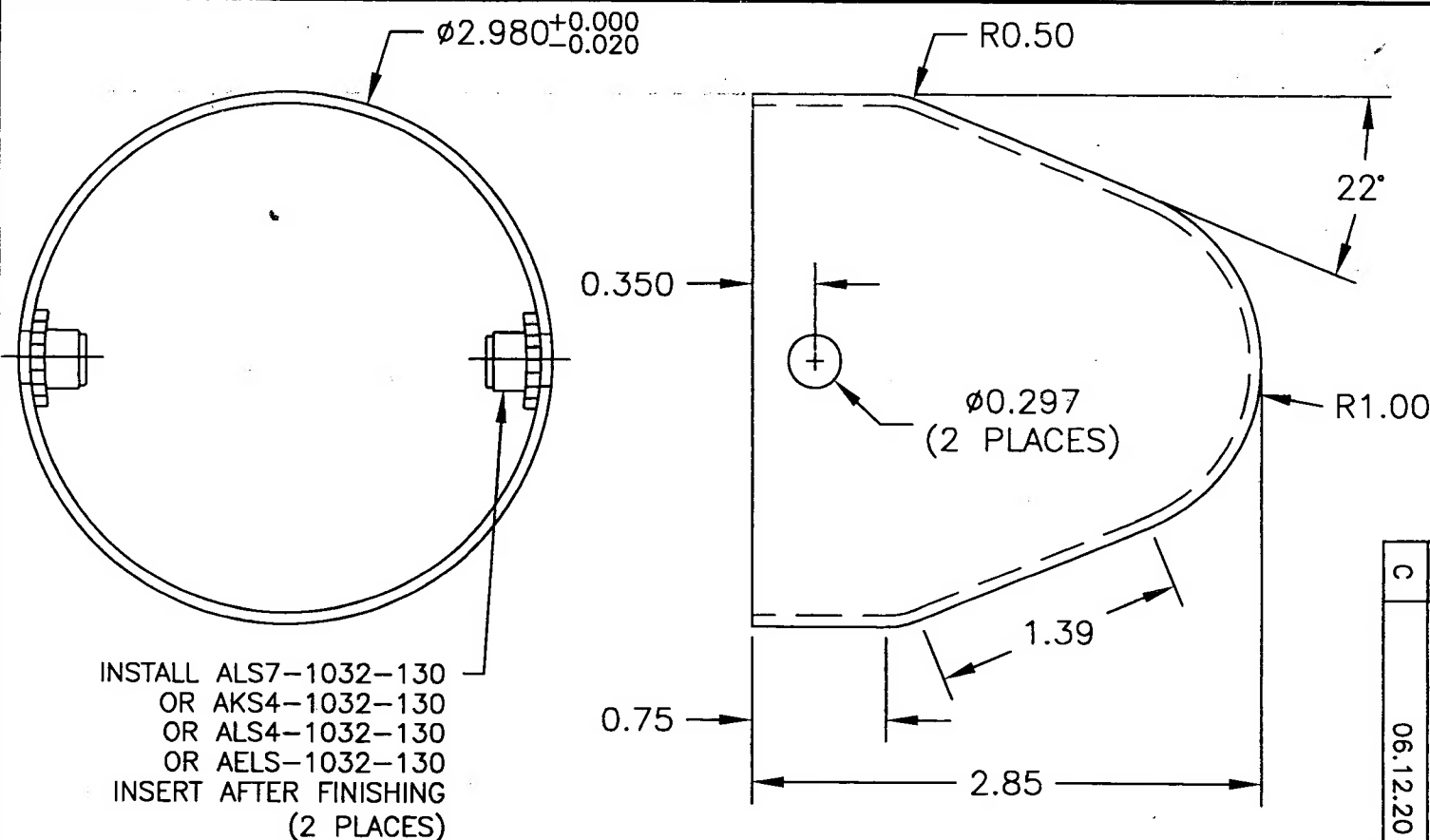
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DS	DRAWN BY	PH	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. C
CHECKED		APPROVED		DRAWING NO.	D2646	SHEET 1 OF 1
DATE	06.12.20			TITLE	AFT CAP	SCALE
						1:1
A		97.03.25		NEW ISSUE		
B		05.04.01		CHANGE TO CLOSED INSERTS		
C		06.12.20		CHANGE TO OPEN ENDED INSERTS		



D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31335

RELEASED
07.02.20



1480 Manheim Pike
Lancaster Pa 17601

CERTIFICATION OF TEST RESULTS

SOLD TO

COPPER & BRASS SALES INC
22355 WEST ELEVEN MILE ROAD
SOUTHFIELD, MI 48034

SHIP TO

COPPER & BRASS SALES INC
6555 E. DAVIDSON
DETROIT, MI 48212

CERT NO 0000598687
DATE 10/26/2004
SKID NO 322296
SKID WGT 9,760
PAGE 1 OF 1

ORDER NO	LB4176	PO NO	C99792
ITEM NO	1	PART NO	050393-8
ALLOY	1100	TEMPER	O
GAUGE	.06300	WIDTH	48.0000
		FORM	COIL
		LENGTH	0.0000

MILL FINISH
NON ANODIZE QUALITY
OUT: STANDARD MILL FINISH
IN: STANDARD MILL FINISH
NOT EMBOSSED

LOT: 238066 COIL: B01 DROP: 440525

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
4405252	0.11	0.42	0.08	0.02	0.002	0.001	0.004	0.003	0.02

HEAD ULTIMATE STRENGTH 12.2 KSI
TAIL ULTIMATE STRENGTH 12.6 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 4.9 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.6 KSI
HEAD ELONGATION (G.L. = 2 IN) 35.5 %
TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 O, AMS 4001H 1100 O,
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL
** END OF CERTIFICATION **

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By:

JBFF FREEDY, LAB SUPERVISOR

Handwritten:
HAW
Henry C. Shaw
C/O
Sorel
LTS

15048320685

51995

